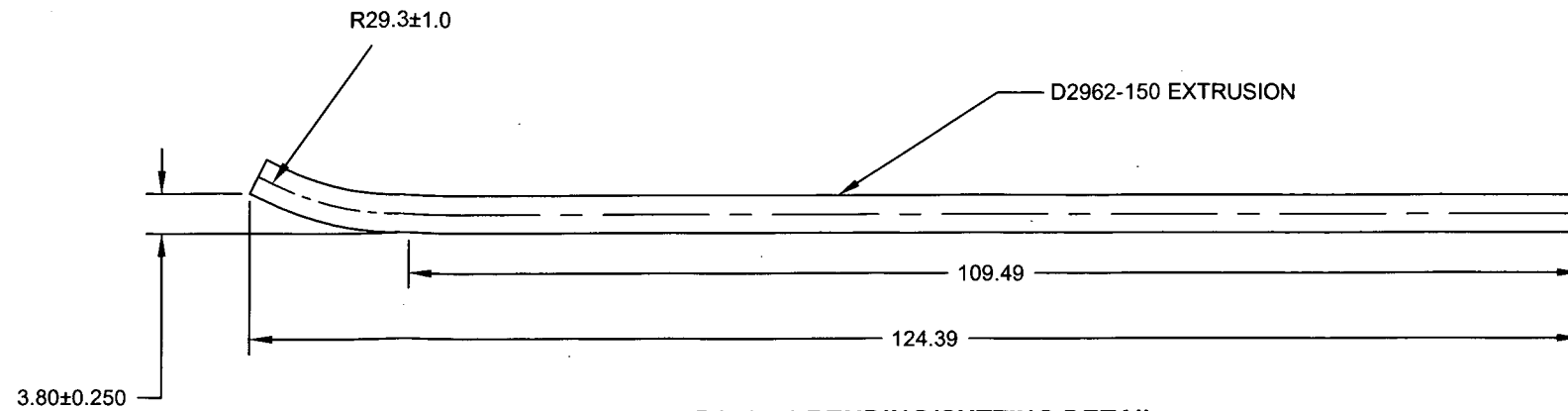
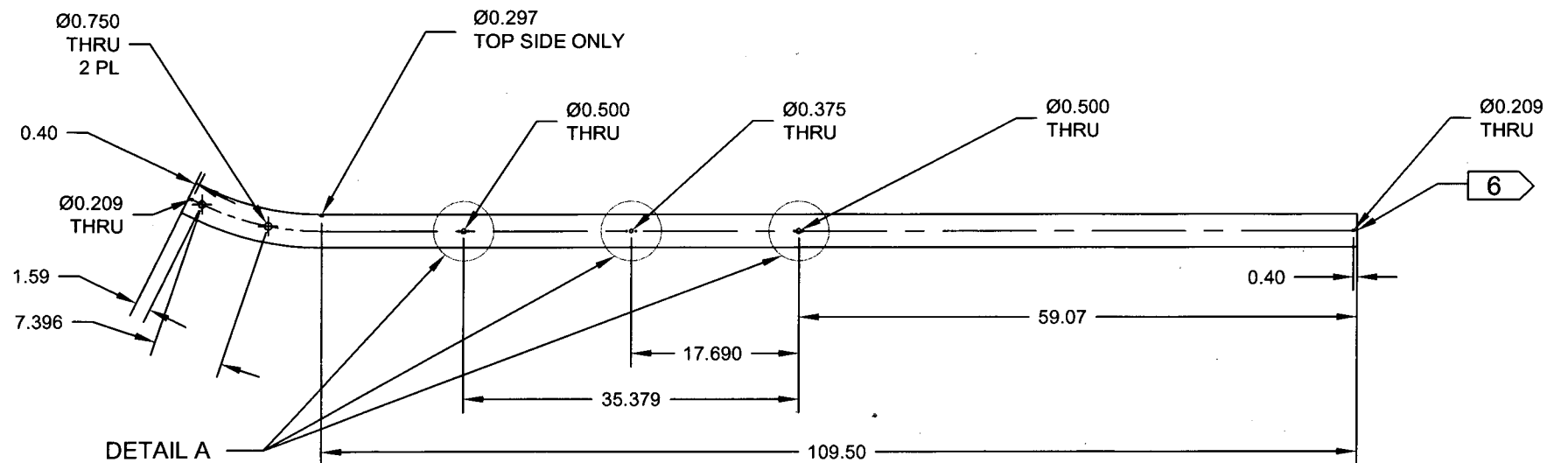


Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

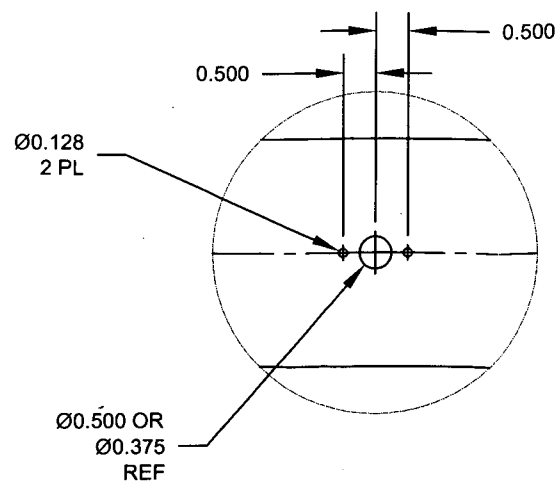
- GENERAL NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.  
OPTIONAL: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE.
  - 7) WEIGHT: 24.1 LB (FROM IIN-D135-751)
  - 8) WELDING TO BE DONE PER DART QSI 004
  - 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
  - 10) USE DART DRILL TEMPLATE DT8888 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
  - 11) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS



**D3507-1 BENDING/CUTTING DETAIL**

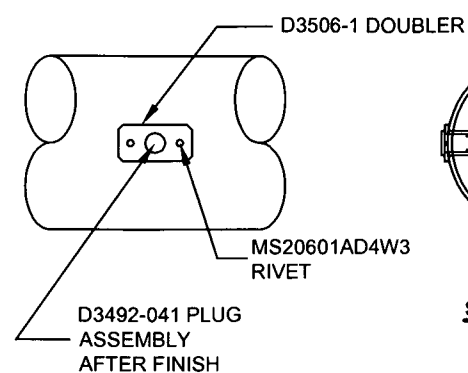


**D3507-1 DRILLING DETAIL**



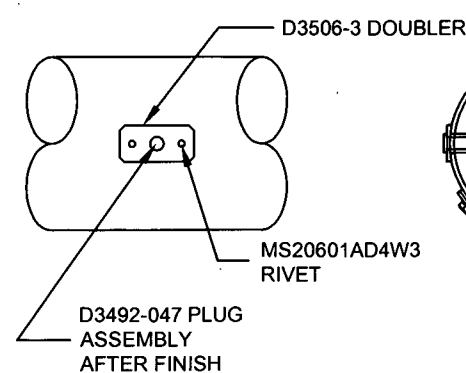
**DETAIL A**  
TYP, 6 PL  
SCALE 3:10

D	REMOVE D3558-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	<b>DART AEROSPACE USA, INC</b> KENT, WA	
DRAWN	DW		
CHECKED	UP	DRAWING NO. REV. D D3507 SHEET 1 OF 2	
MFG. APPR.	AA		
APPROVED	W	TITLE SCALE EC 135 SKIDTUBE NTS	
DE APPR.	CH		
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



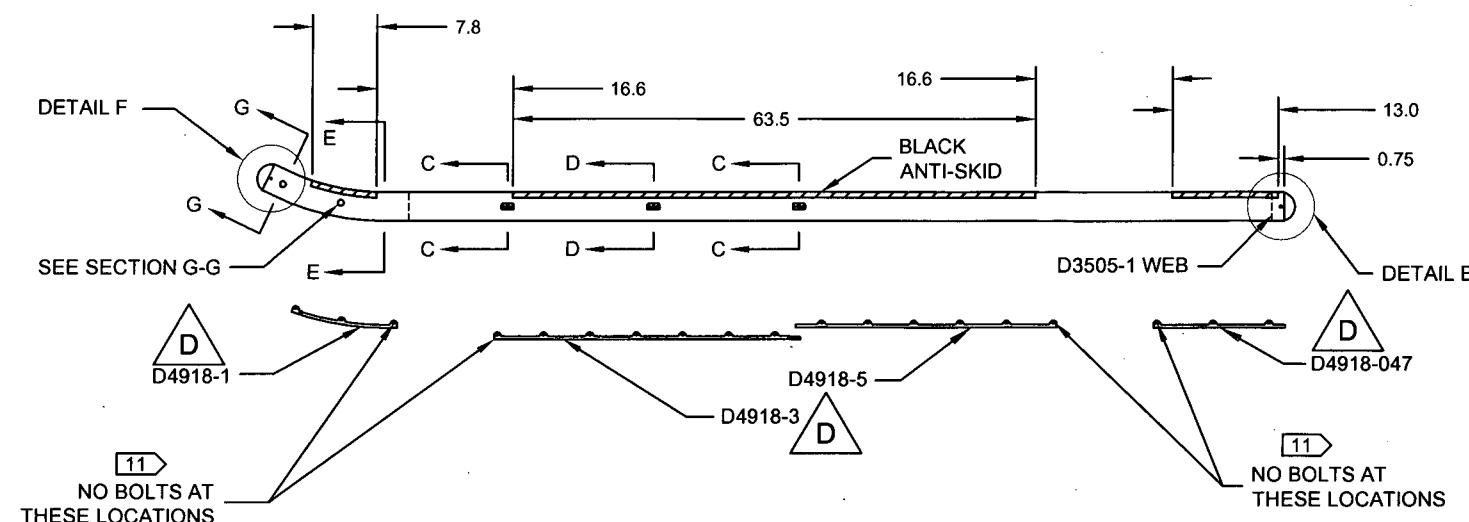
**SECTION C-C**  
(SCALE 3:10)

- AFTER BENDING AND DRILLING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.404 (Y' DRILL) THRU HOLE
  5. INSTALL D3506-1 DOUBLER 4 PL USING MS20601AD4W3 RIVET 8 PL
  6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL

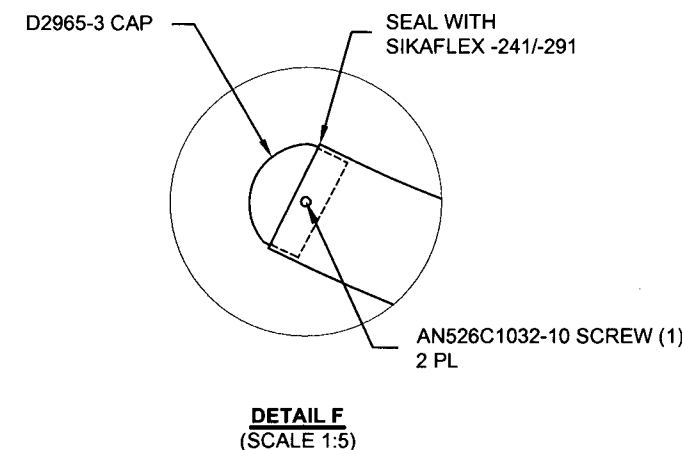


**SECTION D-D**  
(SCALE 3:10)

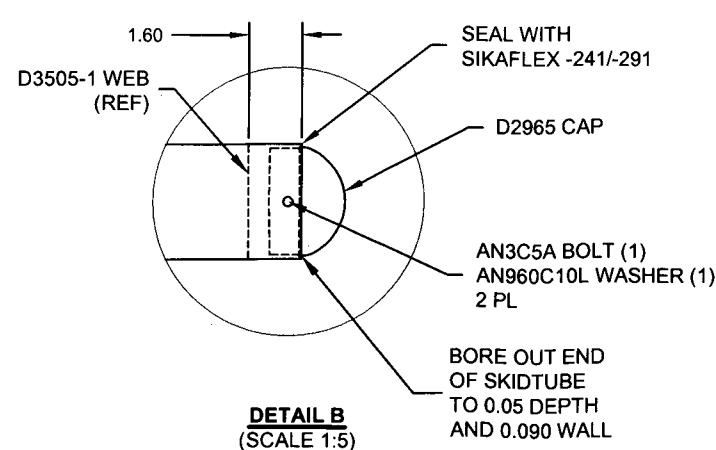
- AFTER BENDING AND DRILLING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.277 (J' DRILL) THRU HOLE
  5. INSTALL D3506-3 DOUBLER 2 PL USING MS20601AD4W3 RIVET 4 PL
  6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL



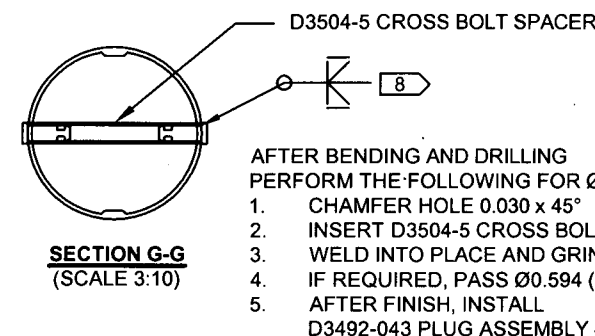
**D3507-041 ASSEMBLY DETAIL**



**DETAIL F**  
(SCALE 1:5)

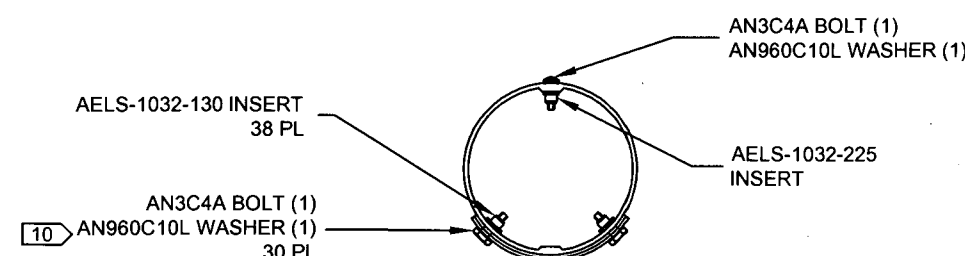


**DETAIL B**  
(SCALE 1:5)



**SECTION G-G**  
(SCALE 3:10)

- AFTER BENDING AND DRILLING  
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
  5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



**SECTION E-E**  
(SCALE 3:10)

RELEASED  
2013-12-10

DESIGN	DW	<b>DART AEROSPACE USA, INC</b>	
DRAWN	DW	KENT, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.		D3507	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		EC 135 SKIDTUBE	NTS
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